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(54) **GERMANIUM-BASED QUANTUM WELL DEVICES**

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H01L 29/267 (2006.01)

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CPC ... **H01L 29/66553** (2013.01); **H01L 21/02532** (2013.01); **H01L 21/02546** (2013.01); **H01L 21/283** (2013.01); **H01L 29/155** (2013.01);
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None
See application file for complete search history.

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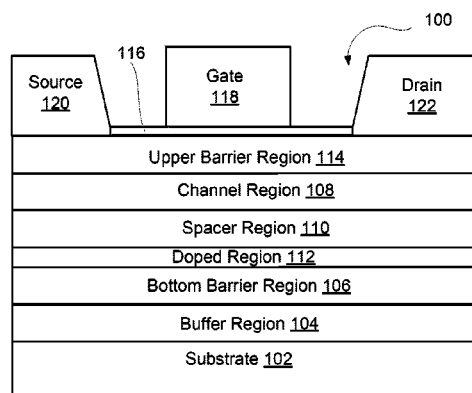
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(57) **ABSTRACT**

A quantum well transistor has a germanium quantum well channel region. A silicon-containing etch stop layer provides easy placement of a gate dielectric close to the channel. A group III-V barrier layer adds strain to the channel. Graded silicon germanium layers above and below the channel region improve performance. Multiple gate dielectric materials allow use of a high-k value gate dielectric.

14 Claims, 15 Drawing Sheets



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H01L 29/778 (2006.01)
H01L 29/775 (2006.01)
H01L 29/51 (2006.01)

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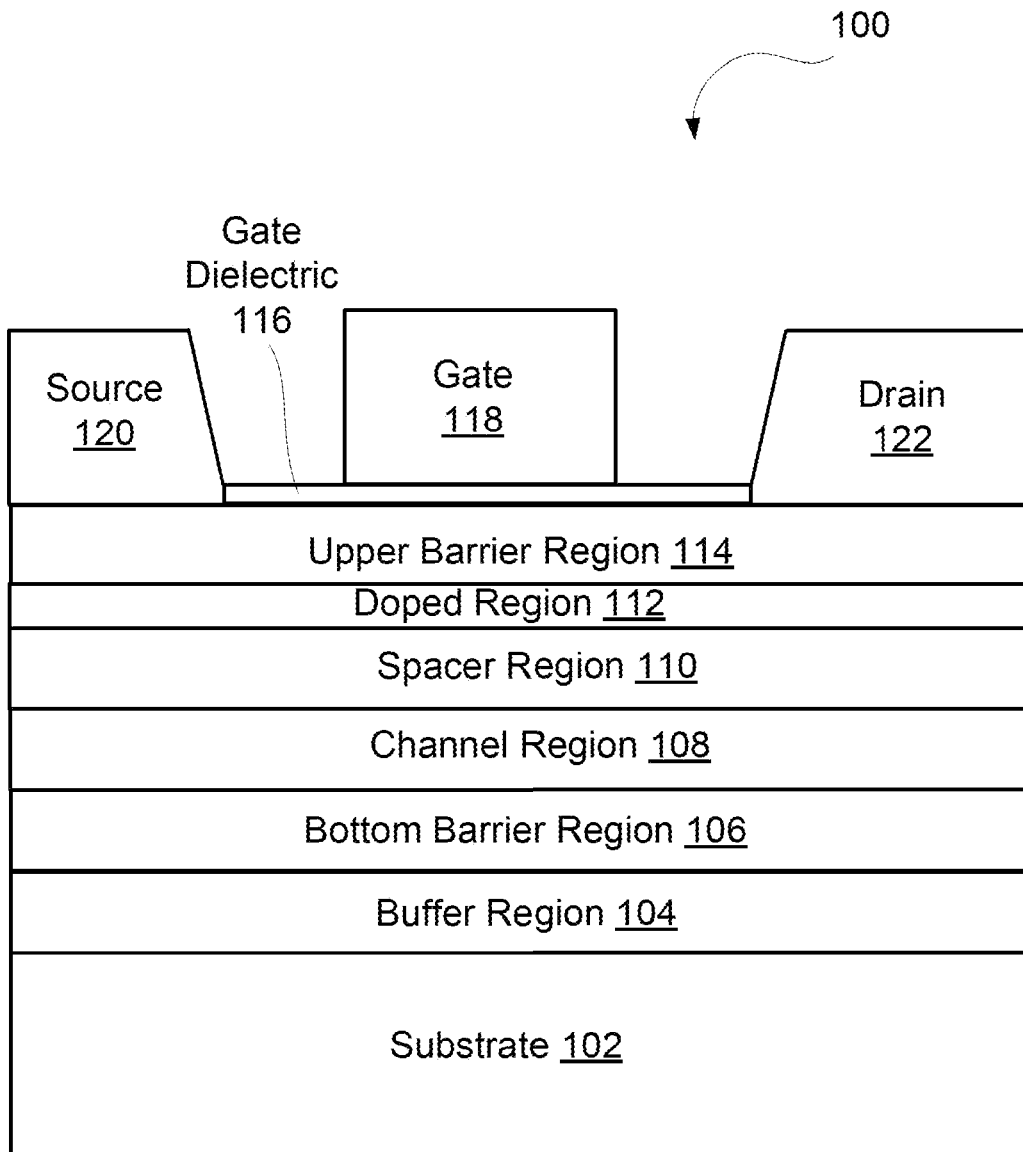


Figure 1

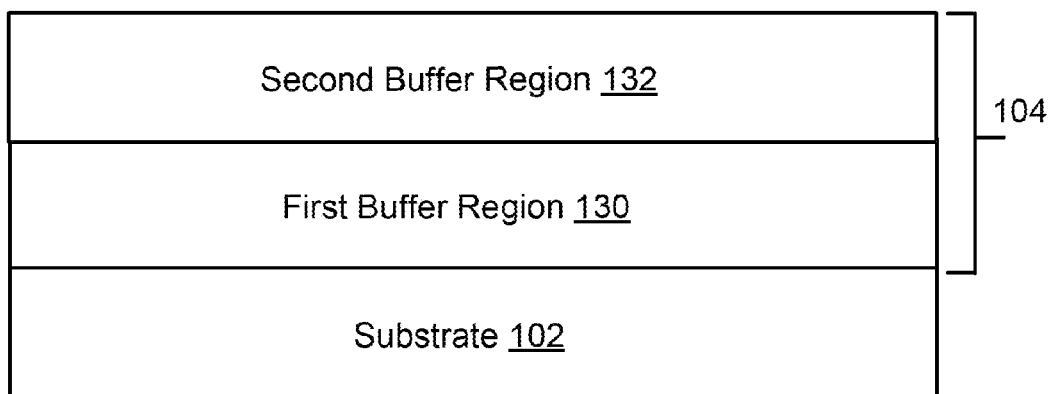


Figure 2

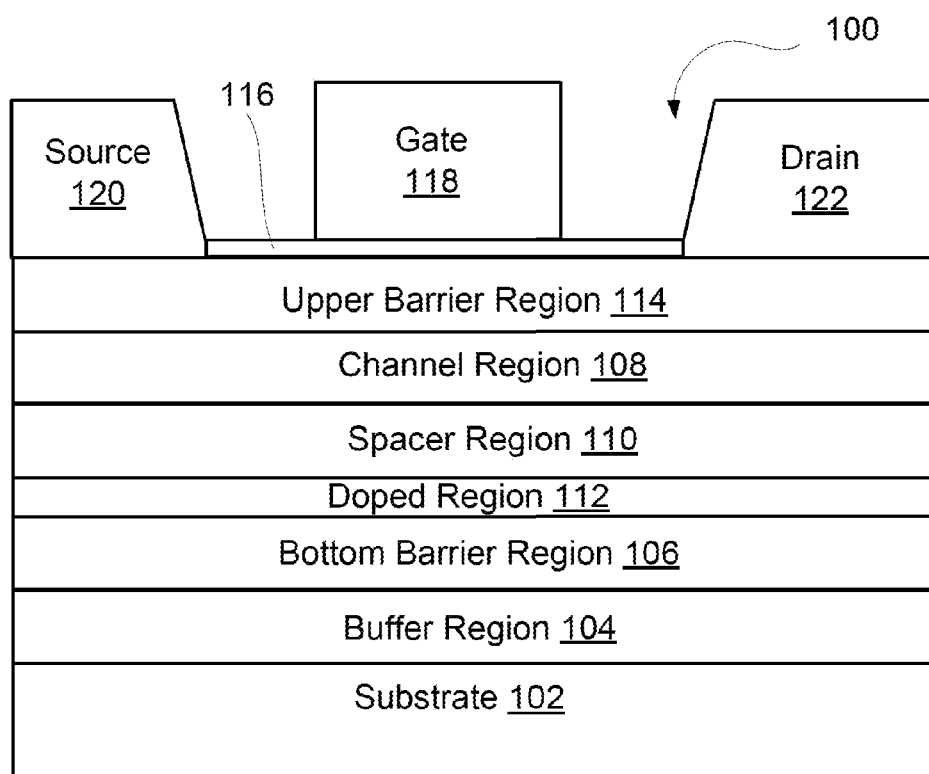


Figure 3

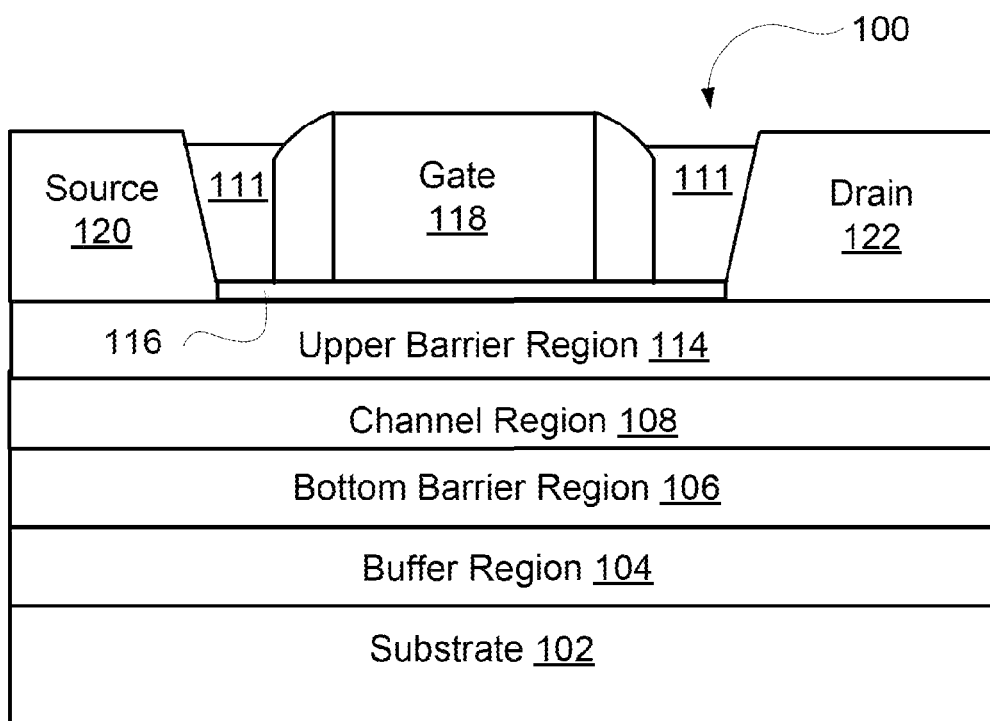


Figure 4

Contact Region <u>244</u>
Upper Barrier Region <u>214</u>
Doped Region <u>212</u>
Upper Spacer Region <u>242</u>
Etch Stop Region <u>240</u>
First Spacer Region <u>210</u>
Channel Region <u>208</u>
Lower Barrier Region <u>206</u>
Buffer Region <u>204</u>
Substrate <u>202</u>

Figure 5

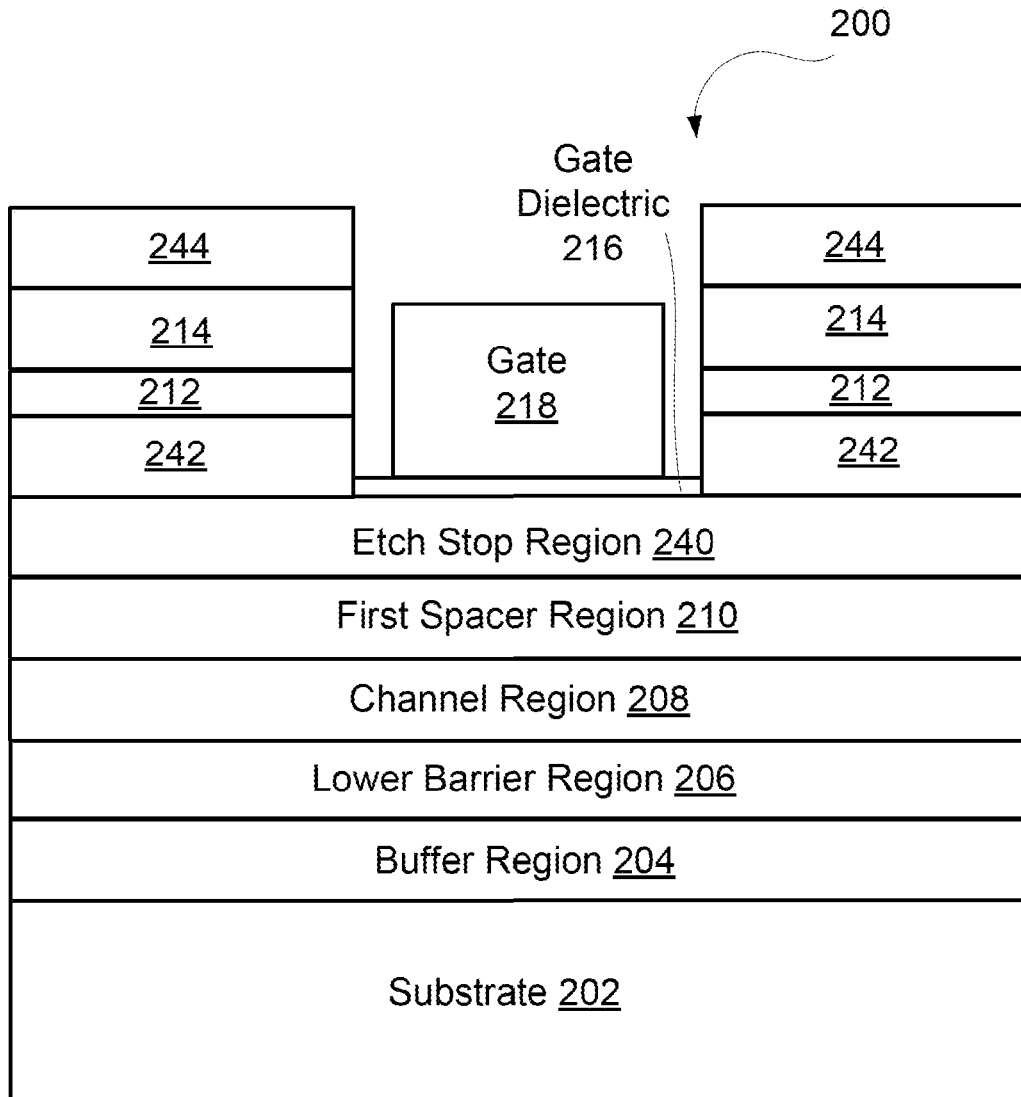


Figure 6

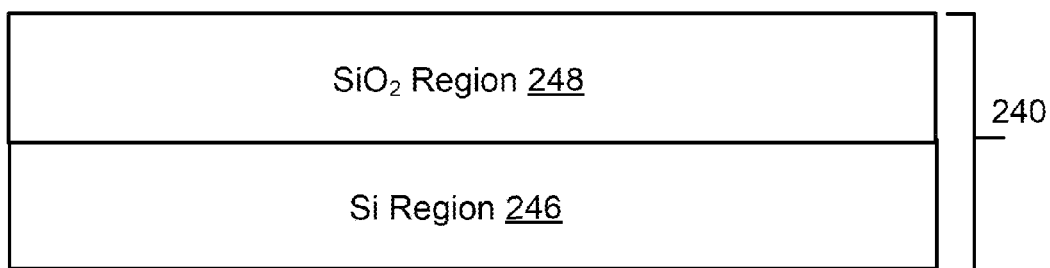


Figure 7

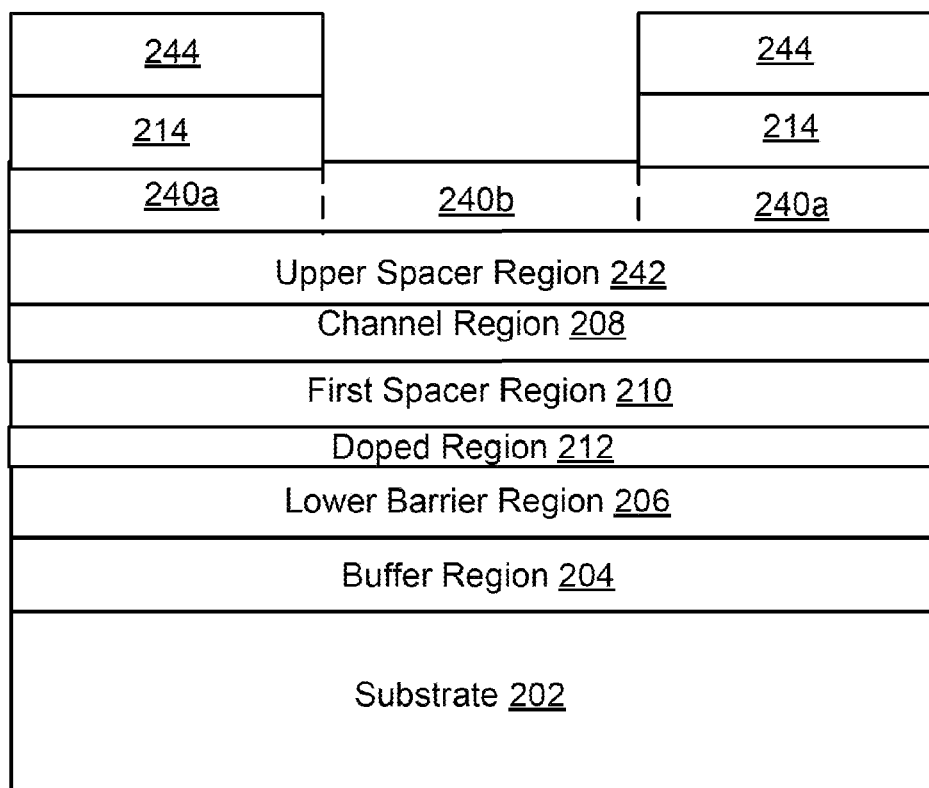
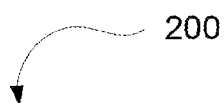


Figure 8

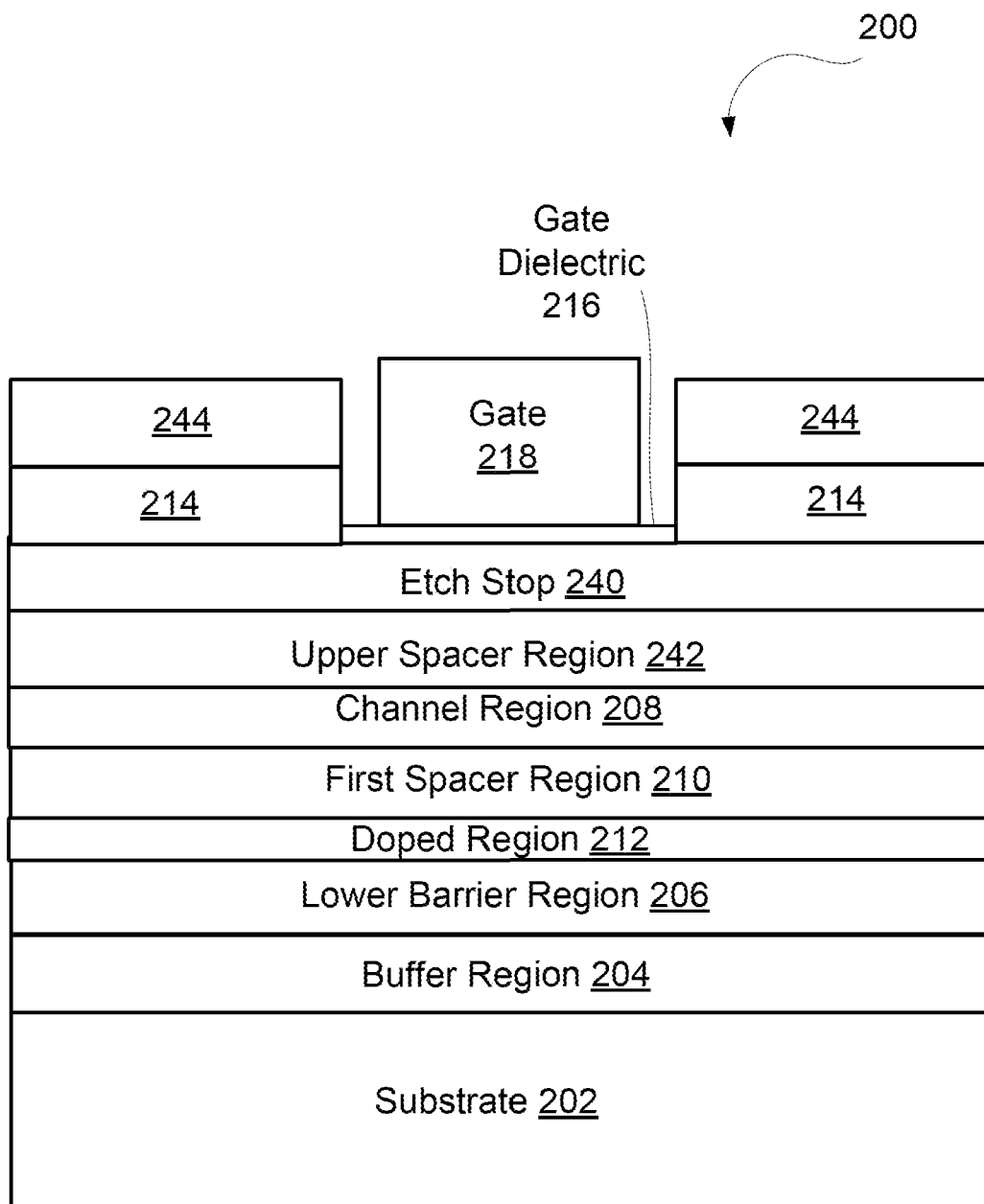


Figure 9

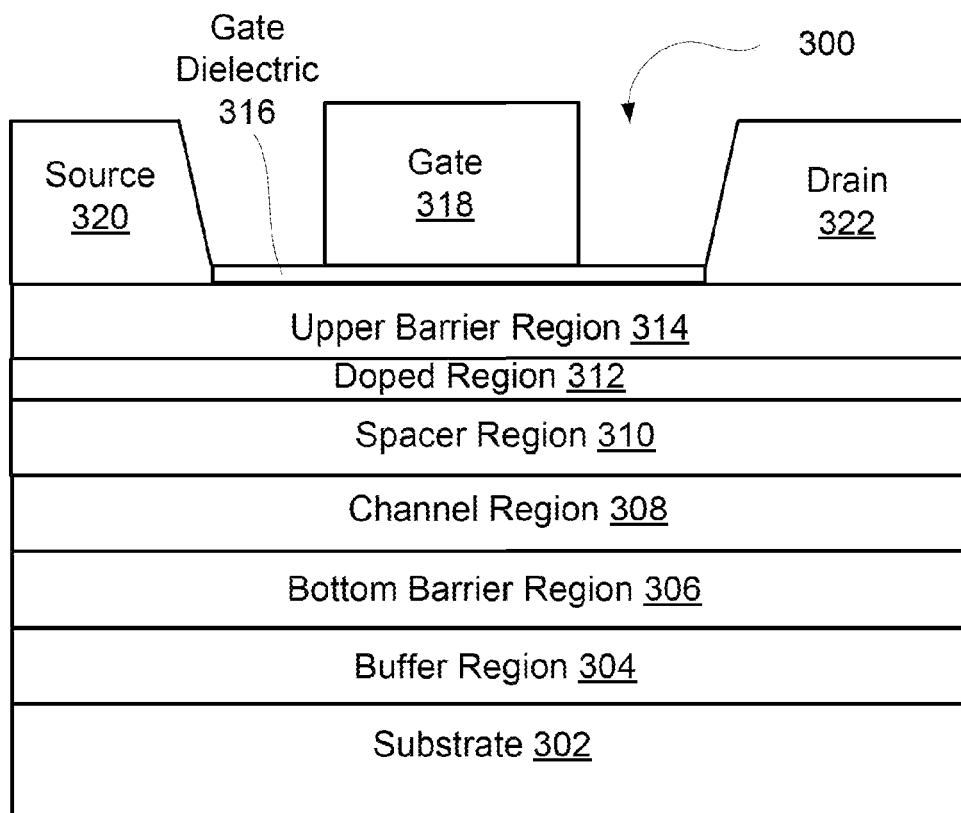


Figure 10

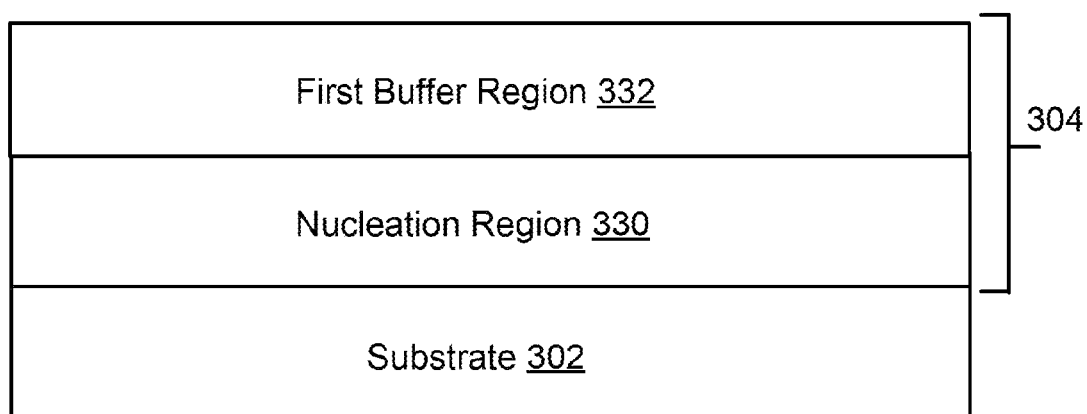


Figure 11

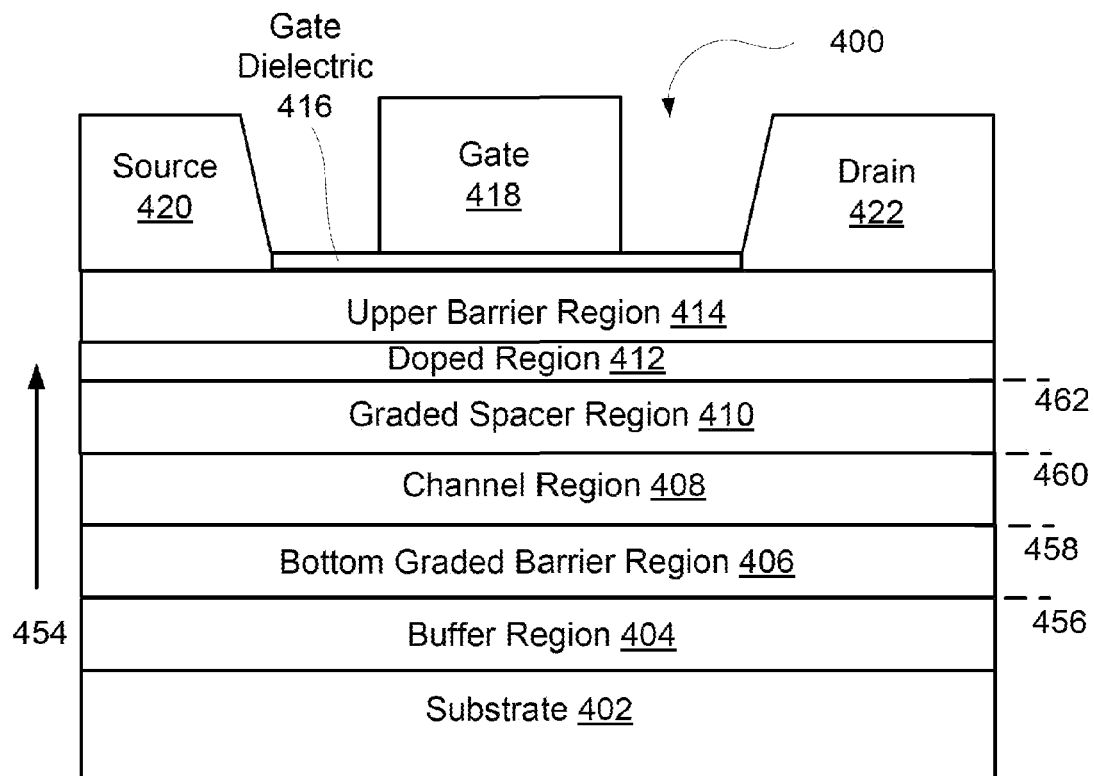


Figure 12

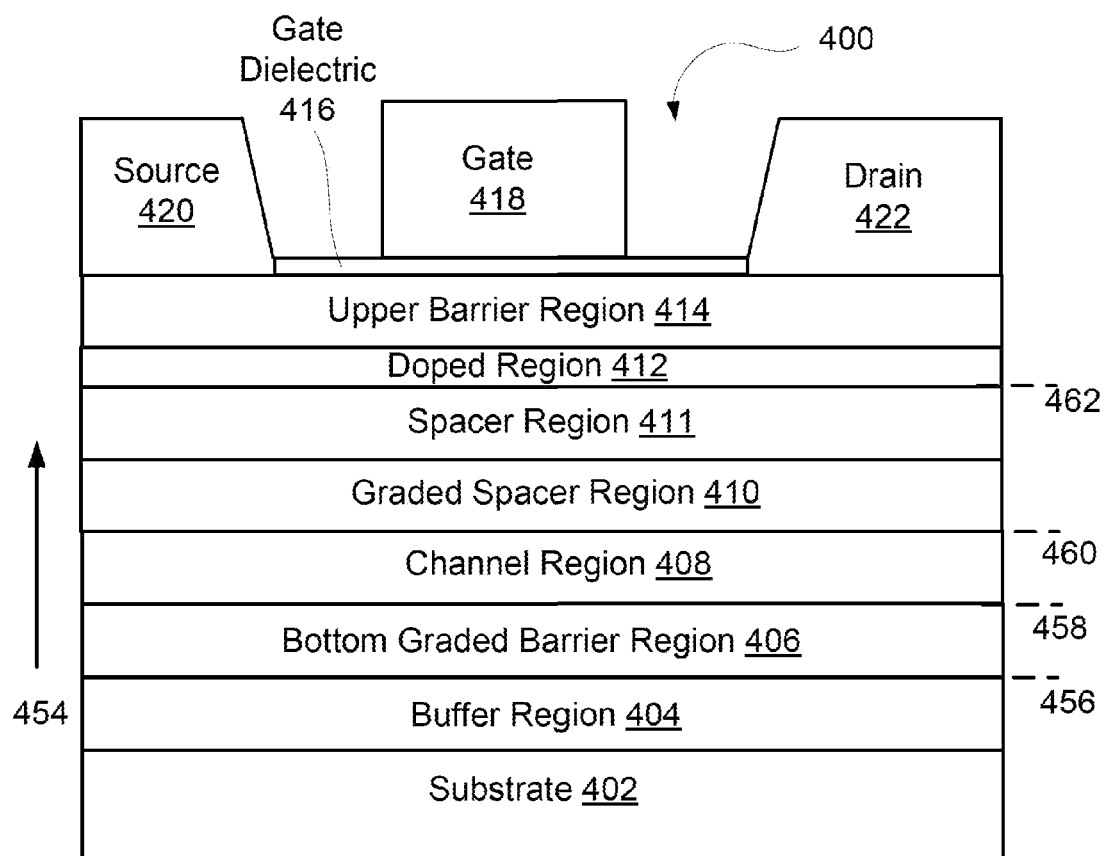


Figure 12a

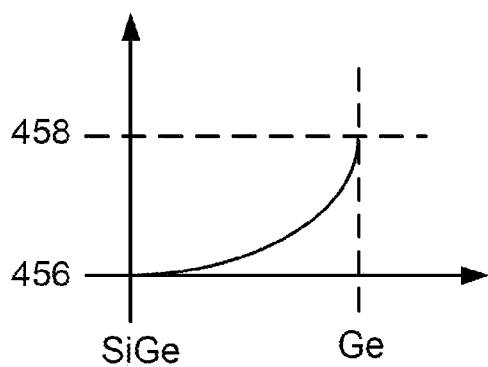


Figure 13

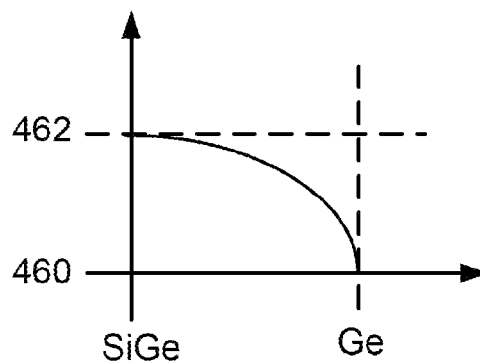


Figure 14

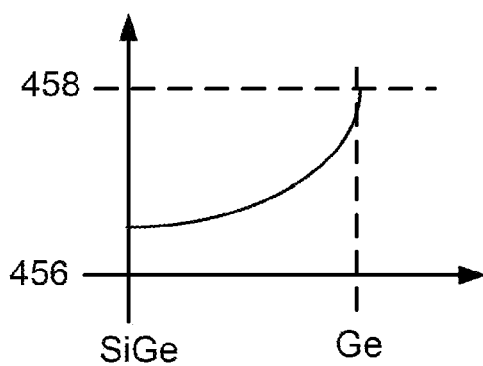


Figure 15

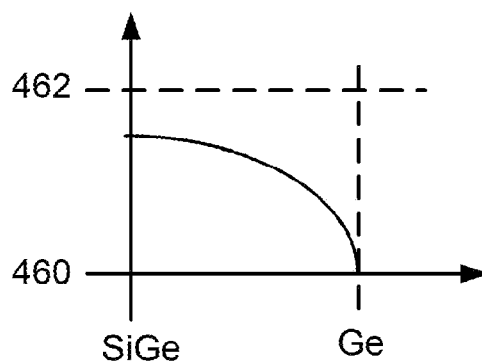


Figure 16

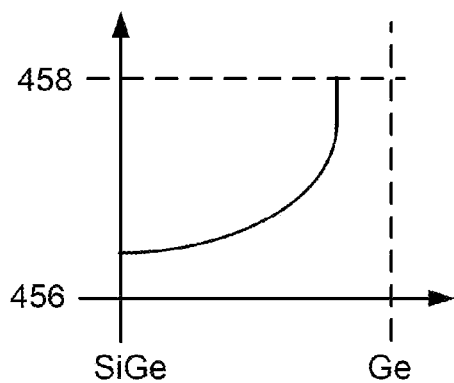


Figure 17

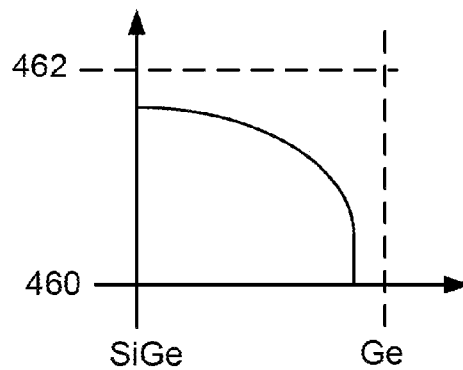


Figure 18

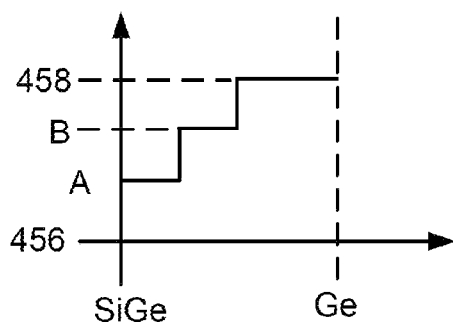


Figure 19

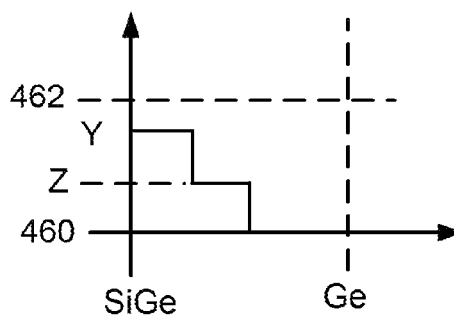


Figure 20

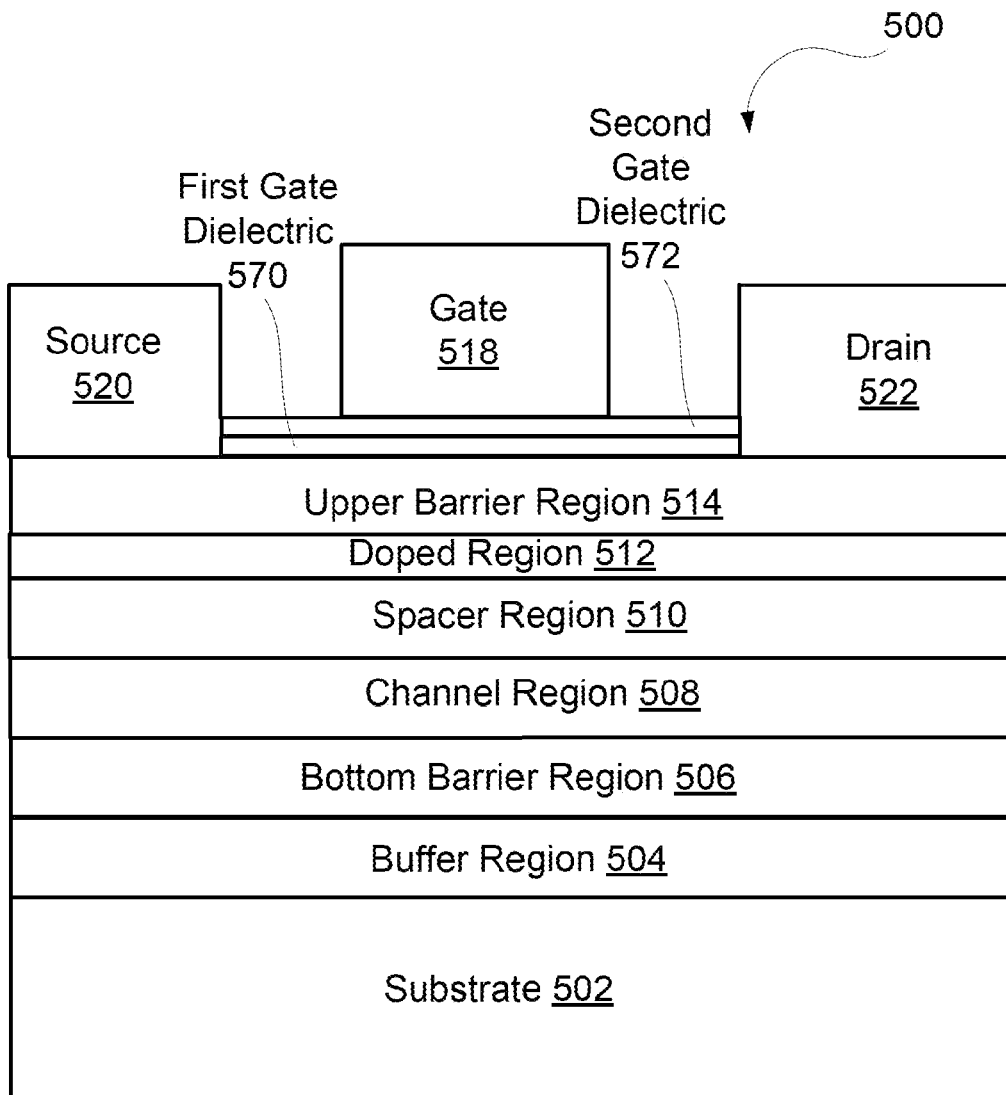


Figure 21

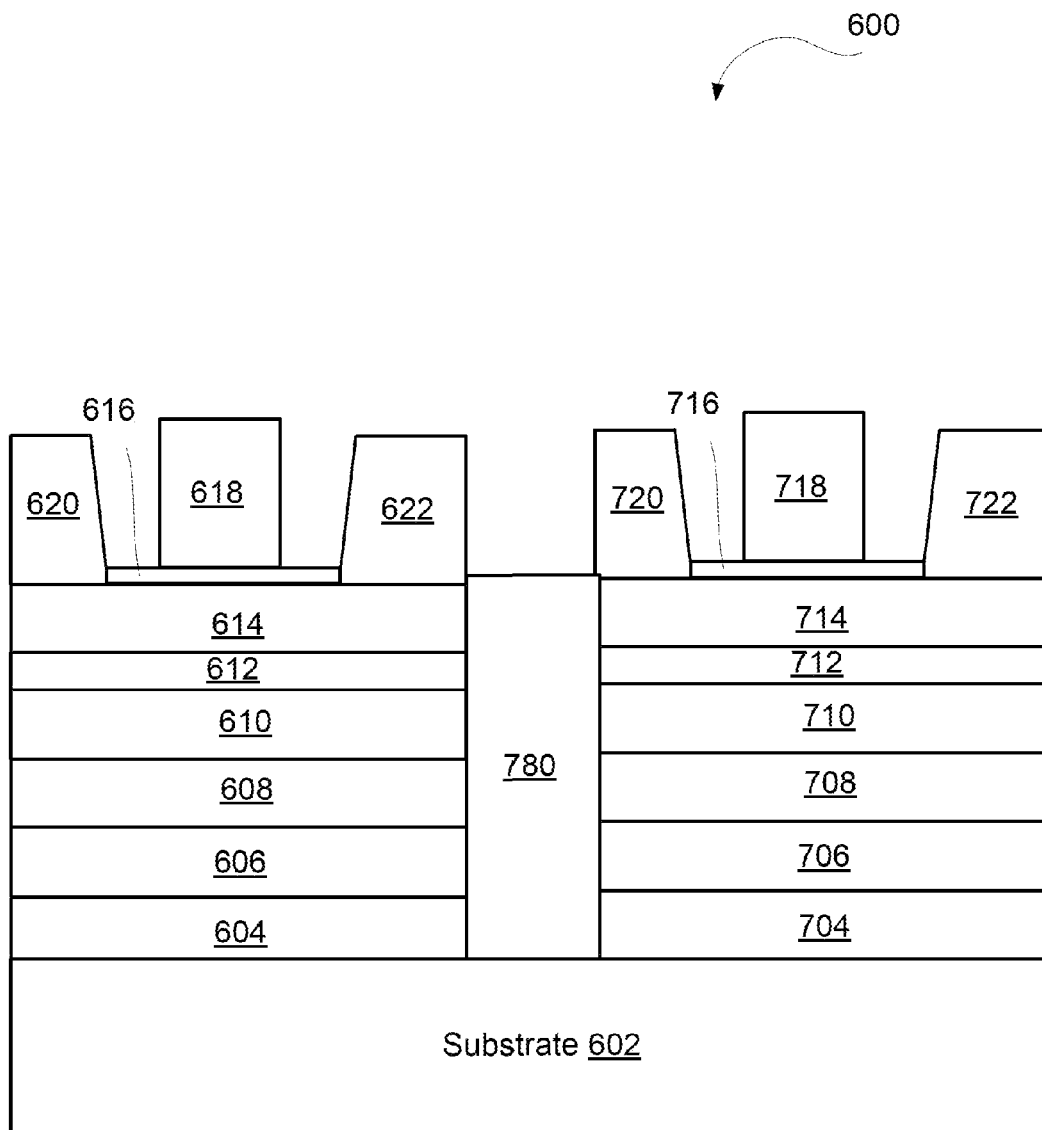


Figure 22

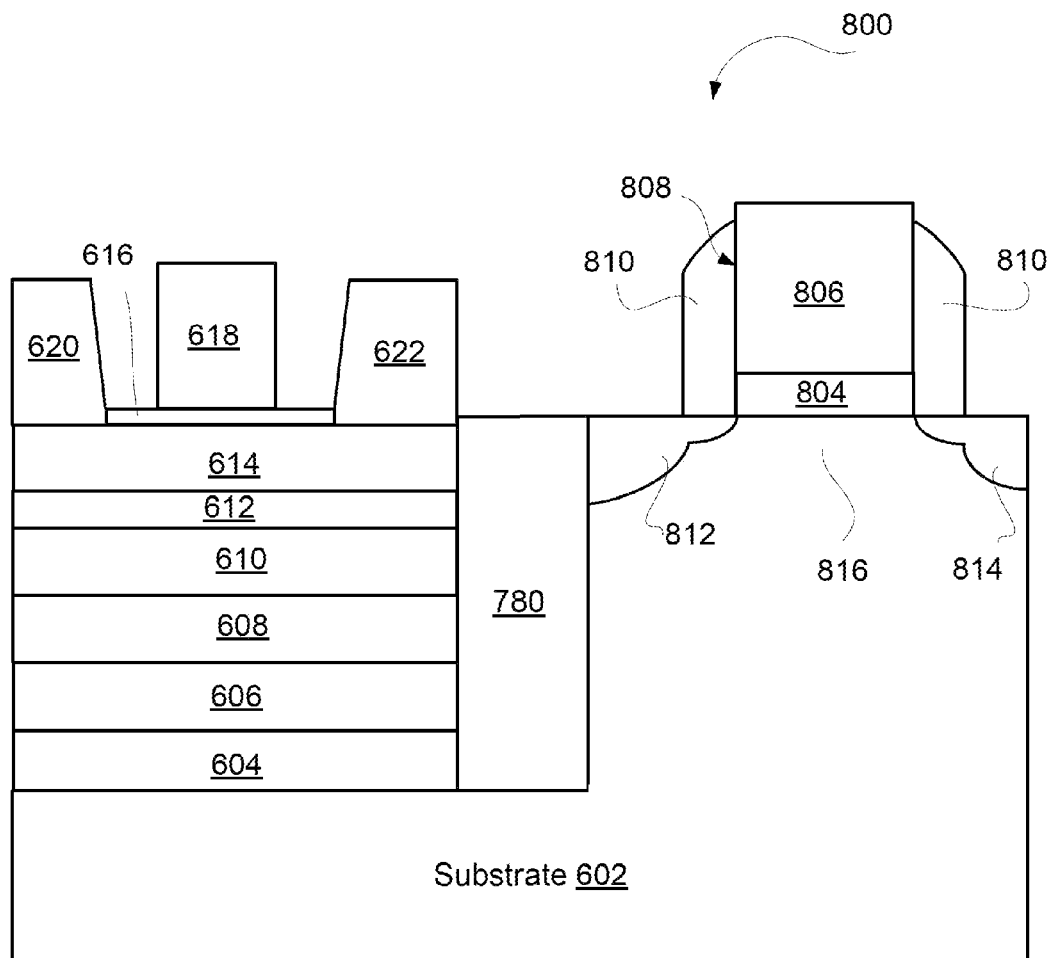


Figure 23

1

GERMANIUM-BASED QUANTUM WELL DEVICES

RELATED APPLICATIONS

The present application is a Continuation of U.S. patent application Ser. No. 14/057,204, filed on Oct. 18, 2013, entitled "GERMANIUM-BASED QUANTUM WELL DEVICES", which is a Continuation of U.S. patent application Ser. No. 13/442,098, filed on Apr. 9, 2013, now issued U.S. Pat. No. 8,592,803 granted on Nov. 26, 2013, entitled "GERMANIUM-BASED QUANTUM WELL DEVICES", which is a Divisional of U.S. patent application Ser. No. 12/655,468, filed on Dec. 30, 2009, now issued U.S. Pat. No. 8,193,623 granted on Jun. 5, 2012, entitled "GERMANIUM-BASED QUANTUM WELL DEVICES".

BACKGROUND

Background of the Invention

Most integrated circuits today are based on silicon, a Group IV element of the Periodic Table. Quantum well transistors based on non-silicon materials may provide superior device performance.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a cross sectional side view that illustrates a germanium quantum well channel transistor device.

FIG. 2 is a cross sectional side view that illustrates a buffer region that is formed on the substrate.

FIG. 3 is a cross sectional side view that illustrates another embodiment of a germanium quantum well channel transistor device.

FIG. 4 is a cross sectional side view that illustrates another embodiment of a germanium quantum well channel transistor device.

FIG. 5 is a cross sectional side view that shows a material stack that may be used to form another embodiment of a germanium quantum well channel transistor device.

FIG. 6 is a cross sectional side view that illustrates a germanium quantum well channel transistor device.

FIG. 7 is a cross sectional side view that illustrates the etch stop region present in some embodiments.

FIG. 8 is a cross sectional side view that illustrates what portion of the etch stop region may be altered in an embodiment.

FIG. 9 is a cross sectional side view that illustrates a germanium quantum well channel transistor device, according to another embodiment of the present invention.

FIG. 10 is a cross sectional side view that illustrates a germanium quantum well channel transistor device, according to another embodiment of the present invention.

FIG. 11 is a cross sectional side view that illustrates multiple subregions of a buffer region that comprises a group III-V material.

FIG. 12 is a cross sectional side view that illustrates a germanium quantum well channel transistor device that has one or more non-homogenous barrier and/or spacer regions.

FIG. 12a is a cross sectional side view that illustrates a germanium quantum well channel transistor device having a non-graded spacer region between a graded spacer region and a doped region.

FIGS. 13 through 20 are graphs that illustrate bottom barrier and spacer region material compositions according to various embodiments of the present invention.

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FIG. 21 is a cross sectional side view that illustrates a germanium quantum well channel transistor device that has multiple gate dielectric regions.

FIG. 22 is a cross sectional side view that illustrates a device with a germanium quantum well channel region transistor and a group III-V material quantum well channel region transistor on the same substrate.

FIG. 23 is a cross sectional side view that illustrates a device with a germanium quantum well channel region transistor and a non-quantum well channel transistor on the same substrate.

DETAILED DESCRIPTION

In various embodiments, a germanium channel quantum well semiconductor device and its fabrication are described. In the following description, various embodiments will be described. However, one skilled in the relevant art will recognize that the various embodiments may be practiced without one or more of the specific details, or with other replacement and/or additional methods, materials, or components. In other instances, well-known structures, materials, or operations are not shown or described in detail to avoid obscuring aspects of various embodiments of the invention. Similarly, for purposes of explanation, specific numbers, materials, and configurations are set forth in order to provide a thorough understanding of the invention. Nevertheless, the invention may be practiced without specific details. Furthermore, it is understood that the various embodiments shown in the figures are illustrative representations and are not necessarily drawn to scale.

Reference throughout this specification to "one embodiment" or "an embodiment" means that a particular feature, structure, material, or characteristic described in connection with the embodiment is included in at least one embodiment that falls within the scope of the invention, but do not denote that they are necessarily present in every embodiment. Thus, the appearances of the phrases "in one embodiment" or "in an embodiment" in various places throughout this specification are not necessarily referring to the same embodiment of the invention. Furthermore, the particular features, structures, materials, or characteristics may be combined in any suitable manner in one or more embodiments. Various additional layers and/or structures may be included and/or described features may be omitted in other embodiments.

Various operations will be described as multiple discrete operations in turn, in a manner that is most helpful in understanding the invention. However, the order of description should not be construed as to imply that these operations are necessarily order dependent. In particular, these operations need not be performed in the order of presentation. Operations described may be performed in a different order, in series or in parallel, than the described embodiment. Various additional operations may be performed and/or described operations may be omitted in additional embodiments.

FIG. 1 is a cross sectional side view that illustrates a germanium quantum well channel transistor device 100, according to one embodiment of the present invention. In the illustrated embodiment, the device 100 includes a substrate 102, which may be any material or materials on which the device 100 may be made. In some embodiments the substrate 102 may be a substantially single-crystal silicon material, a substantially single-crystal silicon material that is doped, a multi-crystal or multi-layer substrate 102, or a semiconductor-on-insulator substrate 102. The substrate 102 may not comprise silicon in some embodiments, but may

instead comprise a different substrate material, such as Ge, GaAs or InP. The substrate **102** may include one or more material(s), device(s), or layer(s), or may be a single material without multiple layers.

The substrate **102** surface on which the device **100** is to be formed may have a resistance between about 1 ohm and about 50,000 ohms per centimeter. The high resistivity may be achieved by a low dopant concentration, lower than about 10^{16} carriers/cm³. In other embodiments, the substrate **102** may have different resistivities or the resistance may be achieved by other methods.

There is a buffer region **104** on the substrate **102** in the illustrated embodiment. The buffer region **104** may function to accommodate for a lattice mismatch between the substrate **102** and regions above the buffer region **104** and to confine lattice dislocations and defects.

There is a lower barrier region **106** on the buffer region **104**, a channel region **108** on the lower barrier region **106**, a first spacer region **110** on the channel region **108**, a doped region **112** on the spacer region **110**, and an upper barrier region **114** on the doped region **112** in the illustrated embodiment.

The lower barrier region **106** may comprise a material with a higher band gap than the material of which the channel region **108** is comprised. The lower barrier region **106** comprises silicon and germanium in the illustrated embodiment, although in other embodiments it may comprise other materials such as InAlAs, InGaAs, GaAs, AlGaAs, InAlSb or InP (note that various materials similar to this may be used in other regions of the device **100** such as the spacer regions and barrier regions). In embodiments where the lower barrier region **106** comprises SiGe, various ratios of Si to Ge may be used. In an embodiment, the bottom barrier region comprises SiGe, so the ratio is 50% Si and 50% Ge. In other embodiments, the ratio may be chosen to impart a strain on the channel region **108** or for other reasons. For example, in an embodiment the bottom barrier region **106** comprises 70% SiGe and 30% Si. In another embodiment, the bottom barrier region **106** comprises between 60% and 80% SiGe and between 40% and 20% Si. In other embodiments, different ratios may be used.

The lower barrier region **106** may be doped or undoped. Any suitable method may be used to form the lower barrier region **106**. In some embodiments, the lower barrier region **106** may have a thickness between about one micron and three microns or less. In an embodiment the lower barrier region **106** has a thickness less than about 500 nanometers, in another embodiment the lower barrier region **106** has a thickness of about 100 nanometers, and in other embodiments it may have yet other thicknesses.

The channel region **108** may be a quantum well channel region **108**. The quantum well channel region **108** comprises Ge. In an embodiment, the channel region consists substantially of all Ge. In other embodiments, there may be other materials, such as Si, as part of the composition of the channel region **108**. As mentioned above, the quantum well channel region **108** may be strained by lattice size mismatch with the layers (such as the bottom barrier region **106**) adjacent to the channel region **108**. In some embodiments, the channel region **106** is not strained. Any suitable method may be used to form the quantum well channel region **108**. In some embodiments, the quantum well channel region **108** may have a thickness between about 3 nanometers and twenty nanometers, although it may be less or more than that in other embodiments. In one embodiment, it has a thickness of about 10 nanometers.

The first spacer region **110** may comprise the same or a similar material as the lower barrier region **106** in one embodiment, may comprise intrinsic undoped SiGe in another embodiment, and in other embodiments it may comprise a different material. The first spacer region **110** may be formed by any suitable method. In one embodiment, the first spacer region **110** has a thickness less than about 5 nanometers. In another embodiment, the first spacer region **110** has a thickness of about 2 nanometers. In other embodiments, the first spacer **110** may have other thicknesses.

The doped region **112** is on the spacer region **110** and is doped according to the design of the device **100** and the targeted threshold voltage of the device **100** in an embodiment. Note that the term “doped region **112**” as used herein may be a modulation doped region, a delta-doped region or another type of doped region in various embodiments.

The doped region **112** may comprise substantially the same material as the spacer region **110**, with the addition of a dopant or dopants. For example, in an embodiment where the spacer region **110** comprises SiGe, the doped region **112** also comprises SiGe with the addition of a dopant. The dopant used in the doped region **112** may be boron or another p-type dopant. There may be a dopant density in the doped region **112** of between about 1×10^{11} /cm² to about 8×10^{12} /cm² in some embodiments, between about zero (undoped) and 5×10^{13} /cm² in other embodiments, although different dopant densities may be used in yet other embodiments. The density of dopants may be chosen based by the device **100** design and targeted threshold voltage of the device. In another embodiment, the doped region **112** may comprise a different material than SiGe that is doped. In some embodiments, the doped region **112** may have a thickness of less than about 50 angstroms. In another embodiment, the doped region **112** has a thickness of about 20 angstroms or less. In other embodiments, the doped region **112** may have other thicknesses.

There is an upper barrier region **114** on the doped region **112** in the device **100** illustrated in FIG. 1. The upper barrier region **114** may comprise intrinsic undoped SiGe in an embodiment, silicon and germanium in varying ratios in other embodiments, Si in another embodiment, other materials in other embodiments, and may consist of substantially the same material as the lower barrier region **106** and/or the spacer region **110** in yet other embodiments. The upper barrier region **114** may comprise a material with a larger band gap than the channel region **108** in an embodiment. The upper barrier region **114** may be formed by any suitable method. In one embodiment, the upper barrier region **114** has a thickness less than about 5 nanometers. In another embodiment, the upper barrier region **114** has a thickness of about 2 nanometers. In other embodiments, the upper barrier region **114** may have other thicknesses. This thickness may be chosen based on the targeted threshold voltage for the device **100**.

In an embodiment, the spacer region **110**, doped region **112**, and the upper barrier region **114** may be formed with a continuous growth process. For example, the spacer region **110** can comprise SiGe and be formed in a chamber. To form the doped region **112** the precursor flows are changed to include the dopant. To form the upper barrier region **114**, the precursor flows are changed again to those used to form the spacer region **110**. In other embodiments, different ways to form the regions may be used and the regions **110**, **112**, **114** may not have so similar a composition.

There is a gate dielectric **116** on the upper barrier region **114** and a gate **118** on the gate dielectric **116** in the illustrated embodiment. The gate dielectric **116** may comprise a mate-

rial with a high dielectric constant (high-k dielectric). The gate dielectric **116** may comprise a material with a high dielectric constant (high-k dielectric) such as Al_2O_3 , although other materials such as La_2O_3 , HfO_2 , ZrO_2 , TaO_5 , or ternary complexes such as LaAl_xO_y , $\text{Hf}_x\text{Zr}_y\text{O}_z$ or other materials may be used in other embodiments. In embodiments where the gate dielectric **116** is Al_2O_3 , the Al_2O_3 may be deposited using trimethylaluminum (TMA) and water precursors with an ALD process in one embodiment, although other methods to form it may be used. In an embodiment, the gate dielectric **116** has a thickness between about 0.7 nanometers and 5 nanometers, in another embodiment the gate dielectric **116** has a thickness less than 5 nanometers, and in other embodiments the gate dielectric **116** may have different thicknesses.

The gate **118** may comprise a metal-containing material such as Pt/Au, Ti/Au, Ti/Pt/Au, or another material or materials. In various embodiments, the material or materials of the gate **118** may be chosen to provide a desired work-function. Source **120** and drain **122** regions may be formed adjacent the gate dielectric **116** and/or gate **118**. In one embodiment, the source and drain regions may comprise NiGeAu. In another embodiment, the source and drain regions may comprise TiPtAu. In other embodiments, the source and drain regions **120**, **122** may comprise another material or materials.

FIG. 2 is a cross sectional side view that illustrates a buffer region **104** that is formed on the substrate **102** in one embodiment. The buffer region **104** may function to accommodate for a lattice mismatch between the substrate **102** and regions above the buffer region **104** and to confine lattice dislocations and defects. In the illustrated embodiment, the buffer region **104** has multiple regions: a first buffer region **130** and a second buffer region **132**, although in other embodiments the buffer region **104** may have different numbers of regions or simply be a single region.

In an embodiment the substrate **102** comprises silicon, the bottom barrier region **106** comprises SiGe, and the first and second buffer regions **130**, **132** comprise silicon and germanium in different amounts. For example, in an embodiment the first buffer region **130** comprises 30% SiGe with substantially all the rest being Si, and the second buffer region **132** comprises 70% SiGe with substantially all the rest being Si. Such an arrangement is a stepped buffer region **104**, with discrete regions having increasing amounts of Ge. More than two stepped buffer regions and/or different changes in material amounts may be present in other embodiments.

In another embodiment there is a single graded buffer region **104** rather than multiple stepped buffer regions. The graded buffer region **104** comprises $\text{Si}_x\text{Ge}_{1-x}$, with x ranging between 1 (or another selected starting amount) at the bottom of the buffer region **104** adjacent the substrate **102** to 0.5 (or another selected ending amount) at the top of the buffer region **104** adjacent the bottom barrier region **106**.

In yet another embodiment there is a single non-graded buffer region **104** with a substantially homogenous SiGe (intrinsic or in a selected ratio with Si or another material) composition all the way from the bottom of the buffer region **104** adjacent the substrate **102** to the top of the buffer region **104** adjacent the bottom barrier region **106**.

In embodiments with different materials in the substrate **102** and/or bottom barrier region **106**, the buffer region **104** may also comprise a different material selected to form a relaxed top portion with reduced defects compared to the bottom of the buffer region **104**. For example, in an embodiment where the bottom barrier region **106** comprises GaAs,

the top portion of the buffer region **104** may comprise Ge, which is substantially lattice-matched to GaAs. The buffer region **104** may thus be graded so there is increasing Ge and decreasing Si further from the substrate **102**, may be stepped to have more Ge and less Si further from the substrate **102**, or may simply be a layer of Ge. In other material schemes, different buffer regions **104** with different materials and buffering may be used.

The buffer region **104** (and any sub-regions **130**, **132**) may have sufficient thickness that most defects present at its bottom surface are not present at its top surface. Any suitable method may be used to form the buffer region **104**.

In some embodiments, the buffer region **104** may also include a nucleation region between the first buffer region **130** and the substrate **102**. For example, an embodiment may have a substrate **102** with an offcut vicinal surface and a III-V material, such as GaAs, buffer region **104**. The nucleation region comprises gallium arsenide in one embodiment, although other materials such as GaSb or AlSb may be used in other embodiments. (Note that as used herein, when materials designated by their elements without subscripts, these designations encompass any mix of percentages of the elements. For example, "InGaAs" encompasses $\text{In}_x\text{Ga}_{1-x}\text{As}$, with x ranging between zero (GaAs) and one (InAs). Similarly, InAlAs encompasses $\text{In}_{0.52}\text{Al}_{0.48}\text{As}$.) It is formed by molecular beam epitaxy (MBE), migration enhanced epitaxy (MEE), metal-organic chemical vapor deposition (MOCVD), atomic layer epitaxy (ALE), chemical beam epitaxy (CBE), or another suitable method. It may be annealed after formation to reduce dislocations. It has a thickness of less than about 1000 angstrom in some embodiments, a thickness of less than about 500 angstroms in some other embodiments. In one embodiment, the nucleation region has a thickness of about 300 angstroms. In embodiments where the substrate **102** is a vicinal silicon material, the nucleation region may be made sufficiently thick to fill all the terraces of the silicon substrate **102**. In an alternative embodiment, other suitable nucleation region materials or thicknesses may be used, or the nucleation region may be omitted.

Such a device with a Ge-based quantum well channel region **106** may provide a p-type transistor that provides better performance than other types of transistors.

FIG. 3 is a cross sectional side view that illustrates a germanium quantum well channel transistor device **100**, according to one embodiment of the present invention. The device **100** of FIG. 3 is similar to the device of FIG. 1, but with the doped region **112** and spacer region **110** below the channel region **108** rather than above the channel region **108**. This allows the channel region **108** to be closer to the gate **118** and may provide increased performance.

FIG. 4 is a cross sectional side view that illustrates a germanium quantum well channel transistor device **100**, according to one embodiment of the present invention. The device **100** of FIG. 3 is similar to the device of FIG. 1, but lacks the doped region **112** and spacer region **110** in the material stack from which the device **100** is formed. Instead, there is a doped region **111** elsewhere in the device **100**, which may be formed after the formation of the gate dielectric **116** and gate **118**. In the illustrated embodiment, there are spacers on either side of the gate **118** and a doped region **111** between the spacer and the contact stack. The doped region **111** in such a device may have different sizes, shapes and placements, and there may or may not be spacers in such an alternative device. Forming a device **100** with a doped region **111** that is not a blanket layer as part of the material stack may simplify creation of the device **100**.

FIG. 5 is a cross sectional side view that shows a material stack that may be used to form another embodiment of a germanium quantum well channel transistor device. This material stack includes a substrate 202, buffer region 204, lower barrier region 206, channel region 208, first spacer region 210, doped region 212 and upper barrier region 214 that may be similar to the substrate 102, buffer region 104, lower barrier region 106, channel region 108, spacer region 110, doped region 112 and upper barrier region 114, respectively, that are described above. The illustrated embodiment also includes an etch stop region 240 on the first spacer region 210 and an upper spacer region 242 on the etch stop region 240 and beneath the doped region 212.

In an embodiment, the spacer region 210 comprises SiGe, the etch stop region 240 comprises silicon and is substantially free from germanium, and the upper spacer region 242 comprises SiGe. In some embodiments, the upper spacer region 242 and lower spacer region 210 consist of substantially the same material, while in other embodiments there may be differences in composition of the two regions 210, 242. In some embodiments, the materials of the spacer regions 210, 242 and the etch stop region 240 are chosen to provide etch selectivity with a chosen etchant or etchants between the first spacer region 210 and the etch stop region 240 and between the etch stop region 240 and the upper spacer region 242. In an embodiment where the upper spacer 242 comprises SiGe and the etch stop region 240 comprises Ge, potassium hydroxide may be selected as an etchant that will remove the upper spacer region 242 and stop at the etch stop region 240. Other etchants and/or materials may be used in other embodiments. In an embodiment, both the etch stop region 240 and the lower spacer region 210 are thin. For example, the etch stop region 240 is ten angstroms thick or less and the first spacer region 210 is also ten angstroms thick or less. In other embodiments, either or both of the etch stop region 240 and first spacer region 210 may have greater thicknesses.

In the embodiment illustrated in FIG. 5, there is also a contact region 244 on the upper barrier region 214. This contact region 244 may be used to form source and drain contacts. In an embodiment, the contact region 244 comprises a p+ doped SiGe material, which may have boron as the dopant at a density of between about $1 \times 10^{19}/\text{cm}^2$ to about $1 \times 10^{22}/\text{cm}^2$ in. Other dopants, other concentrations, and other materials besides SiGe may be used in other embodiments.

FIG. 6 is a cross sectional side view that illustrates a germanium quantum well channel transistor device 200, according to one embodiment of the present invention. This device 200 may be formed from the material stack illustrated in FIG. 5 and may also have a gate dielectric 216 and gate 218 similar to those described with respect to the device 100 of FIG. 1. The device 200 has a recessed gate 218. As there is etch selectivity between the upper spacer region 242 and the etch stop region 240, the upper spacer region 242 (and other material above) may be removed leaving only a thin etch stop region 240 and first spacer region 210 between the channel region 208 and the gate dielectric 216. In embodiments such as device 100 that lack an etch stop region 240 it may be more difficult to get the channel region 108 as close to the gate 118 as the channel region 208 in FIG. 6 is, and thus it may be easier to achieve better performance with the device 200 of FIG. 6.

Additionally, it may be difficult to form a high-k gate dielectric 216 on SiGe. The presence of an etch stop region 240 that comprises a different material such as silicon may

allow formation of a high-k gate dielectric 216 much more easily than if the device 200 lacked the etch stop region 240.

Adjacent the gate dielectric 216 and gate 218 are additional regions that are not beneath the gate dielectric 216 and gate 218. In the illustrated embodiment, these additional regions include the remaining portions of the upper spacer region 242, a doped region 212 on the upper spacer region 242, remaining portions of the upper barrier region 214 on the doped region 212, and remaining portions of the contact region 244 on the upper barrier region 214. These additional regions may be considered a contact stack, with a contact stack being shown on either side of the gate dielectric 216 and gate 218 in FIG. 6.

FIG. 7 is a cross sectional side view that illustrates the etch stop region 240 present in some embodiments. As seen in FIG. 7, the etch stop region 240 may include multiple regions. In an embodiment, the etch stop region 240 may include a first silicon region 246 and a second silicon dioxide region 248. The second silicon dioxide region 248 may be formed by oxidizing silicon of the etch stop region 240 after removal of a portion of the upper spacer region 242 above the etch stop region 240 to expose the portion of the etch stop region 240. As illustrated in FIG. 7, only an upper portion of the etch stop region 240 is oxidized, but in other embodiments, the whole thickness of the etch stop region 240 may be oxidized so that the etch stop region 240 under the gate 218 lacks a silicon region 246. Such a silicon dioxide region 248 may be formed if, for example, it would be easier to form the desired gate dielectric 216 material on silicon dioxide than on silicon. In other embodiments, different alterations to some or all of the etch stop region 240 beneath the gate 218 may be done by the addition, subtraction, or altering of material.

FIG. 8 is a cross sectional side view that illustrates what portion of the etch stop region 240 may be altered in an embodiment. Regions 240a may remain silicon, while the region 240b that will be under the gate 218 is altered as described above. As described above, the entire thickness of region 240b may be altered (for example converted from silicon to silicon dioxide) or only a portion of the thickness. In other embodiments, the boundaries between the altered 240b and unaltered 240a regions of the etch stop region 240 may be in different places, and in some embodiments, the etch stop region 240 may not have an altered region 240b at all.

FIG. 9 is a cross sectional side view that illustrates a germanium quantum well channel transistor device 200, according to another embodiment of the present invention. This device 200 is similar to the device 200 of FIG. 6, but has the spacer region 210 and doped region 212 beneath the channel region 208 rather than above the channel region 208. In such an embodiment, the doped region 212 extends laterally so it exists below the gate 218 and does not end at the edge of the contact stacks.

In yet another embodiment (not pictured), the device is similar to the device 200 of FIG. 9, but lacks the doped region 212 and spacer region 210. Instead, there is a doped region elsewhere in the device, similar to the doped region 111 in the device 100 pictured in FIG. 4.

FIG. 10 is a cross sectional side view that illustrates a germanium quantum well channel transistor device 300, according to another embodiment of the present invention. In the device 300 of FIG. 10, one or more of the buffer region 304, barrier regions 306, 314, spacer region 310, or doped region 312 comprise a group III-V material while the channel region 308 comprises (or substantially consists of) Ge. A group III-V material includes a group III element and

a group V element, such as gallium arsenide (GaAs), indium antimonide (InSb), indium phosphide (InP), and indium gallium arsenide (InGaAs).

For example, in an embodiment, the buffer region **304** comprises a group III-V material, the bottom barrier region **306**, spacer region **310**, and upper barrier region **314** comprise undoped GaAs, the channel region comprises Ge, and the doped region **312** comprises GaAs doped with Be, C, or Si. Such a device may provide better band offsets than if materials other than group III-V materials are used in those regions **304**, **306**, **310**, **312**. AlAs, AlGaAs, or other group III-V materials may be used in place of GaAs in some or all of the regions **304**, **306**, **310**, **312**.

In embodiments where the buffer region **304** comprises a group III-V material, the buffer region **304** may include multiple subregions **330**, **332**, as seen in FIG. 11. The substrate **302** may comprise high-resistivity p-type or n-type vicinal silicon material having regular arrays of double-stepped (**100**) terraces across the substrate surface in some embodiments. A vicinal surface may be prepared by offcutting the substrate **302** from an ingot. In some embodiments, the (**100**) substrate surface is offcut at an angle between 2 and 8 degrees towards the [110] direction. In a particular embodiment, the (**100**) substrate surface is offcut at an angle of about 4 degrees towards the [110] direction. A vicinal surface is a higher order crystal plane of the silicon substrate **302**, such as, but not limited to the (211), (511), (013), (711) planes. In other embodiments, the substrate **302** may not have been offcut or have a vicinal surface.

The substrate **302** surface on which the device **300** is to be formed may have a resistance between about 1 ohm and about 50,000 ohms per centimeter. The high resistivity may be achieved by a low dopant concentration, lower than about 10^{16} carriers/cm³. In other embodiments, the substrate **302** may have different resistivities or the resistance may be achieved by other methods.

In some embodiments the substrate **302** may be a substantially single-crystal silicon material, a substantially single-crystal silicon material that is doped, a multi-crystal or multi-layer substrate **302**. In various embodiments, the substrate **302** could comprise germanium, germanium on silicon, or could be a silicon-on-insulator substrate **302**. The substrate **302** may not comprise silicon in some embodiments, but may instead comprise a different material, such as a different semiconductor or Ge or a group III-V material such as GaAs or InP. The substrate **302** may include one or more material(s), device(s), or layer(s), or may be a single material without multiple layers.

The buffer region **304** on the substrate **302** may function to accommodate for a lattice mismatch between the substrate **302** and regions above the buffer region **304** and to confine lattice dislocations and defects. In the illustrated embodiment, the buffer region **304** has multiple regions: a nucleation region **330** and a first buffer region **332**, although in other embodiments the buffer region **304** may have different numbers of regions or simply be a single region.

The nucleation region **330** comprises gallium arsenide in one embodiment, although other materials such as GaSb or AlSb may be used in other embodiments. (Note that as used herein, when materials designated by their elements without subscripts, these designations encompass any mix of percentages of the elements. For example, "InGaAs" encompasses $\text{In}_x\text{Ga}_{1-x}\text{As}$, with x ranging between zero (GaAs) and one (InAs). Similarly, InAlAs encompasses $\text{In}_{0.52}\text{Al}_{0.48}\text{As}$.) It is formed by molecular beam epitaxy (MBE), migration enhanced epitaxy (MEE), metal-organic chemical vapor deposition (MOCVD), atomic layer epitaxy (ALE), chemi-

cal beam epitaxy (CBE), or another suitable method. It may be annealed after formation to reduce dislocations. It has a thickness of less than about 1000 angstrom in some embodiments, a thickness of less than about 500 angstroms in some other embodiments. In one embodiment, the nucleation region **330** has a thickness of about 300 angstroms. In embodiments where the substrate **302** is a vicinal silicon material, the nucleation region **330** may be made sufficiently thick to fill all the terraces of the silicon substrate **302**. In an alternative embodiment, other suitable nucleation region **330** materials or thicknesses may be used, or the nucleation region **330** may be omitted.

On the nucleation region **330** is a first buffer region **332** in the illustrated embodiment. In an embodiment, the first buffer region **332** comprises a GaAs material, although other materials, such as InAlAs, AlSb, or other materials may be used. In an embodiment, the first buffer region **332** consists substantially the same material as the nucleation region **330**. The buffer region **332** may also be formed by molecular beam epitaxy (MBE), migration enhanced epitaxy (MEE), metal-organic chemical vapor deposition (MOCVD), atomic layer epitaxy (ALE), chemical beam epitaxy (CBE), or another suitable method. The first buffer region **332** may have a thickness of less than one micron, between 0.3 microns and one micron, about 0.3 micron, or another thickness in various embodiments.

The first buffer region **332** may be formed by the same process used to form the nucleation region **330** in some embodiments. In such an embodiment, the growth of the first buffer layer **332** may be performed at a higher temperature than that used for the nucleation layer **304**. While first buffer region **332** may be considered and is shown as a separate region than nucleation region **330**, both regions **330**, **332** may be considered buffers, with region **332** thickening the III-V buffer region started by nucleation region **330**. The film quality of region **332** may be superior to that of the nucleation region **332** because it may be formed at a higher growth temperature. Also, during the formation of region **332**, the flux rate can be relatively high because the polar nucleation region **330** may eliminate danger of anti-phase domains (APD) formation.

The buffer region **332** may be a single thick non-graded buffer region **332**, a multi-stepped buffer region **332**, a graded buffer region **332**, or another form of buffer, similar to the buffer region **104** described with respect to FIG. 2.

Note that some embodiments may lack a nucleation region **330** and/or a buffer region **332**. For example, in embodiments where the substrate **302** comprises a group III-V material, the device **300** may lack nucleation region **330** and/or buffer region **332**. In an embodiment where the buffer region **304** comprises SiGe, the buffer region **304** may lack a nucleation region **330** and be similar to the buffer region **104** described with respect to FIG. 2.

Returning to FIG. 10, in another embodiment the device **300** has a buffer region **304** similar to buffer region **104** and comprising SiGe and a lower barrier region **306** comprising SiGe with a channel region **308** that comprises Ge and an upper barrier region **314** that comprises GaAs or another group III-V material. The SiGe of the lower barrier region **306** (which may be in direct contact with the channel region **308**) can strain the channel region **308** while the group III-V material of the upper barrier region **314** provides improved band offset.

In another embodiment, the bottom barrier region **306** comprises a group III-V material, the buffer region **304** comprises SiGe or a group III-V material, the channel region **308** comprises Ge, and the upper barrier region **314** com-

prises SiGe. Various other combinations of SiGe and group III-V materials in the barrier regions **306**, **314**, spacer region **310**, and buffer region **304** may also be used. Also, embodiments with the doped region **312** and spacer region **310** being under the channel region **308** (as seen in FIG. **3**) or that lack a blanket doped region **312** and instead have alternative doped regions (as doped regions **111** seen in FIG. **4**) are also possible. In addition, the etch stop region **240** and additional spacer region **242** of FIGS. **5-9** may also be used in embodiments of a device **300** that has group III-V material as one or more of the buffer region **304**, barrier regions **306**, **314**, spacer region **310**, or doped region **312**.

FIG. **12** is a cross sectional side view that illustrates a germanium quantum well channel transistor device **400** that has one or more non-homogenous barrier **406**, **414** and/or spacer **410** regions, according to another embodiment of the present invention. Rather than have a homogenous material composition through the thickness of the region(s) **406**, **414**, and/or **410**, the material is non-homogenous to be transitioned to be more similar to the channel region **408** closer to the channel region **408** and less similar to the channel region **408** further from the channel region **408**.

FIG. **12a** is a cross sectional side view similar to FIG. **12**, but includes a non-graded spacer region **411** between the graded spacer region **410** and the doped region **412**. In some embodiments, there may be such a non-graded, relatively homogenous spacer region **411** between the graded spacer region **410** and the doped region **412**. The spacer region **411** may consist substantially of the same material as the top portion of the graded spacer region **410** in some embodiments, although in other embodiments, it may have a different composition.

For example, in an embodiment, the bottom **456** of the lower barrier region **406** comprises SiGe. The channel region **408** consists substantially of germanium. The lower barrier region **406** is graded so that there is more and more germanium until at the top **458** of the lower barrier region **406** it consists substantially of germanium. Similarly, the spacer region **410** is substantially germanium at the bottom **460**. The spacer region **410** is graded so that there is less germanium and more silicon towards the top **462** of the spacer region **410**.

FIGS. **13** and **14** are graphs that illustrate a graded bottom barrier region **406** and spacer region **410** according to one embodiment of the present invention. FIG. **13** is a graph that illustrates the composition of the bottom barrier region **406** between its bottom **456** and top **458**, and FIG. **14** is a graph that illustrates the composition of the spacer region **410** between its bottom **460** and top **462**. As seen in FIG. **13**, the bottom barrier **406** comprises SiGe at its bottom **456**, with more Ge and less Si further towards the top **458**, until at the top **458** the bottom barrier **406** is substantially all Ge (in this embodiment, the channel region **408** is substantially all Ge—in other embodiments, the top **458** of the barrier region **406** reaches a composition substantially the same as the composition of the channel region **408**). FIG. **14** shows the reverse of this with respect to the spacer region **410**: the spacer region **410** is substantially all Ge at the bottom **460** with more Si and less Ge further towards the top **462** until at the top **462** the spacer region **410** is SiGe.

FIGS. **15** and **16** are graphs that illustrate a graded bottom barrier region **406** and spacer region **410** according to one embodiment of the present invention. FIG. **15** is a graph that illustrates the composition of the bottom barrier region **406** between its bottom **456** and top **458**, and FIG. **16** is a graph that illustrates the composition of the spacer region **410** between its bottom **460** and top **462**. As seen in FIG. **15**, the

bottom barrier **406** comprises SiGe at its bottom **456** and remains at the same composition for a portion of its thickness. Then, partway through the thickness of the bottom barrier **406**, the Si starts to decrease and Ge increase, until at the top **458** the bottom barrier **406** is substantially all Ge. FIG. **16** shows the reverse of this with respect to the spacer region **410**: the spacer region **410** is substantially all Ge at the bottom **460** with more Si and less Ge further towards the top **462** until it hits a selected ratio of Si to Ge. It continues at this selected composition until the top **462**. (Note that the embodiment illustrated in FIG. **12a** corresponds to the graph of FIG. **16**—the portion that has a relatively homogenous selected ratio of Si to Ge may be the spacer region **411** rather than a portion of the graded spacer region **410**. Similarly, the bottom portion of bottom barrier **406** may be considered simply a portion of the bottom barrier **406** or may be considered a different relatively homogenous region.)

FIGS. **17** and **18** are graphs that illustrate a graded bottom barrier region **406** and spacer region **410** according to another embodiment of the present invention. FIG. **17** is a graph that illustrates the composition of the bottom barrier region **406** between its bottom **456** and top **458**, and FIG. **16** is a graph that illustrates the composition of the pacer region **410** between its bottom **460** and top **462**. As seen in FIG. **17**, the bottom barrier **406** comprises SiGe at its bottom **456** and remains at the same composition for a portion of its thickness. Then, partway through the thickness of the bottom barrier **406**, the Si starts to decrease and Ge increase, until at the top **458** the bottom barrier **406** has a selected composition. In this embodiment the selected composition at the top **458** is not the same as the composition of the channel region **408**. FIG. **18** shows the reverse of this with respect to the spacer region **410**: the spacer region **410** has a first composition somewhat different from the composition of the channel region **408** at the bottom **460**, and the composition of the spacer region **410** becomes less similar to the composition of the channel region **408** further towards the top **462** until it hits a selected composition and continues at this selected composition until the top **462**.

FIGS. **19** and **20** are graphs that illustrate a stepped bottom barrier region **406** and spacer region **410** according to another embodiment of the present invention. In contrast to the embodiments shown in FIGS. **13-18**, the bottom barrier region **406** and spacer region **410** have discrete steps of changed composition, rather than a relatively smooth gradation. FIG. **19** is a graph that illustrates the composition of the bottom barrier region **406** between its bottom **456** and top **458**, and FIG. **20** is a graph that illustrates the composition of the pacer region **410** between its bottom **460** and top **462**. As seen in FIG. **19**, the bottom barrier **406** comprises SiGe at its bottom **456** and remains at the same composition for a portion of its thickness. The amount of Si increases and Ge decreases in steps rather than smoothly, until at the top **458** the bottom barrier **406** has a selected composition. FIG. **20** shows the reverse of this with respect to the spacer region **410**: the spacer region **410** has decreasing Ge and increasing Si in stepped increments until it hits a selected composition and continues at this selected composition until the top **462**.

While the examples in FIGS. **13** through **20** show SiGe and Ge, these same two compositions were consistently used in each Figure only for clarity. This does not indicate that they are the materials used in all possible embodiments. Different materials in addition to or in place of Si and Ge may be used under the same non-homogenous concept. For example, the bottom barrier region **406** may comprises 60% SiGe and 40% Si at the bottom **456** and include more and

more Ge as one moves towards the top **458**, which may be substantially all Ge or still include some Si. Also, materials other than Si and/or Ge may be used.

Note that while FIGS. **15** and **16** appear to show only a small portion of the thickness of the bottom barrier **406** and spacer **410** having the SiGe composition, the graphs are not to scale, and it may be that the majority of the thicknesses of the bottom barrier **406** and spacer **410** having a homogeneous SiGe composition, with a small portion of their thicknesses including a graded composition change. For example, 80%, 90% or more of the thicknesses of the bottom barrier **406** and spacer **410** may comprise a homogeneous material (in the illustrated case, SiGe), although in other embodiments different percentages of the bottom barrier **406** and spacer **410** may be homogeneous. This is true for the embodiments illustrated in the other graphs of FIGS. **13-20** as well—the graphs are not to scale but merely illustrate that a portion of the thicknesses of the bottom barrier **406** and spacer **410** may form a non-homogeneous transition between material composition of the portions of the bottom barrier **406** and spacer **410** further from the channel region **408** to have a composition more similar to the channel region **408** at locations of the bottom barrier **406** and spacer **410** closer to the channel region **408**, so that the difference between the composition of the channel region **408** and regions immediately adjacent the channel region **408** are not so great.

By having more gradual changes in composition at the boundaries between the bottom barrier region **406** and channel region **408** and between the channel region **408** and the spacer region **410**, the carriers of the device **400** may be better located in the middle of the channel region **408** rather than at an abrupt interface between dissimilar materials of the channel region **408** and a spacer **410** or barrier **406** adjacent the channel region **408**, which may improve device performance.

While FIG. **12** illustrated a device **400** with a doped region **412** above the channel region **408**, the device **400** may have other arrangements while retaining the use of a graded or stepped transition from a first selected composition of the barrier region **406** or spacer region **410** to a composition more similar to the channel region **408** at locations closer to the channel region **408**. Embodiments with the doped region **412** and spacer region **410** being under the channel region **408** (similar to the device seen in FIG. **3**, in which case the upper barrier **414** would have a non-homogeneous transition portion rather than the lower barrier **406**) or that lack a blanket doped region **412** and instead have alternative doped regions (similar to doped regions **111** seen in FIG. **4**, in which case the upper barrier **414** would have a transitional portion instead of the spacer **410**) are also possible. In addition, the etch stop region **240** and additional spacer region **242** of FIGS. **5-9** may also be used in embodiments of a device **400** that has less abrupt material transitions between the channel region **408** and immediately adjacent regions. Also, one or more of the spacer **410**, bottom barrier **406**, or top barrier **414** regions may comprise a group III-V material as is described with respect to FIGS. **10** and **11**.

FIG. **21** is a cross sectional side view that illustrates a germanium quantum well channel transistor device **500** that has multiple gate dielectric regions **570**, **572**, according to another embodiment of the present invention. In some cases a desired gate dielectric material may have compatibility issues with the material on which the gate dielectric is to be formed or other problems. Rather than avoiding that desired gate dielectric material entirely, the gate dielectric may comprise multiple gate dielectric regions **570**, **572**. While

FIG. **21** shows two gate dielectric regions **570**, **572**, more than two may be used in other embodiments.

For example, it may be advantageous to use HfO₂ as a gate dielectric material. However, having HfO₂ in contact with a Ge or SiGe-containing upper barrier region **514** or other region immediately below the gate dielectric may result in various problems that negatively affect the device **500**. To avoid these problems, a first gate dielectric **570** of hafnium silicate may be formed, followed by a second gate dielectric **572** of HfO₂. Other materials such as aluminum oxide, TaSiO, TaSiON, La₂O₃, or other materials can be used for the first gate dielectric region **570**. Other materials such as ZrO₂, Ti₂O₅, Ta₂O₅, HfSiON, HfSiO, or other materials can be used for the second gate dielectric region **572**. The second gate dielectric **572** may have a higher dielectric constant than the first dielectric region **570** in some embodiments, although this is not necessary.

The multiple dielectric regions **570**, **572** of FIG. **21** may be applicable to any of the other embodiments of devices described herein. The doped region **512** may be above the channel region **508**, below the channel region **508**, or elsewhere. The regions immediately adjacent the channel region **508** may have varying composition to avoid an abrupt transition to the material composition of the channel region **508**. The etch stop region **240** and additional spacer region **242** of FIGS. **5-9** may also be used with multiple gate dielectric regions **570**, **572**. Also, one or more of the spacer **510**, bottom barrier **506**, or top barrier **514** regions may comprise a group III-V material as is described with respect to FIGS. **10** and **11**.

FIG. **22** is a cross sectional side view that illustrates a device **600** with a germanium quantum well channel region **608** transistor (on the left side of FIG. **22**) and a group III-V material quantum well channel region **708** transistor (on the right side of FIG. **22**) on the same substrate **602**, according to one embodiment of the present invention. In some embodiments, germanium quantum well channel transistors, such as those shown and described in FIGS. **1-21**, may be used as PMOS transistors while other types of transistors, such as the group III-V material quantum well channel region **708** transistor, may be used as NMOS transistors. These combinations of different types of transistors may make up CMOS circuitry in various different systems, such as a computer central processing unit.

In the embodiment shown in FIG. **22**, the germanium quantum well channel region **608** transistor may have any structure as described herein. One such structure is a substrate **602**, buffer region **604**, bottom barrier region **606**, channel region **608** consisting substantially of germanium, spacer region **610**, doped region **612**, upper barrier region **614**, gate dielectric **616**, gate electrode **618**, source region **620** and drain region **622**. There may be an isolation region **680** between the germanium quantum well channel region **608** transistor and the group III-V material quantum well channel region **708** transistor.

The group III-V material quantum well channel region **708** transistor may comprise many different types of group III-V material quantum well channel region **708** transistors. In one embodiment, it includes a buffer region **704** (which may include a nucleation region) comprising GaAs, a lower barrier region **706** comprising InAlAs, a channel region **708** comprising InGaAs, a spacer region **710** comprising InAlAs, a doped region **712** comprising doped InAlAs, an upper barrier region **714** comprising InAlAs, a gate dielectric **716**, a gate **718**, a source region **720**, and a drain region **722**. In other embodiments, different materials and/or structures

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may be used with the group III-V material quantum well channel region **708** transistor.

As, in some embodiments, a germanium quantum well channel transistor may provide better PMOS performance, and a group III-V material quantum well channel transistor may provide better NMOS performance, the use of both types of transistors on a single substrate **602** may provide better overall device **600** performance than if just one type of transistor were used for both NMOS and PMOS transistors.

FIG. **23** is a cross sectional side view that illustrates a device **800** with a germanium quantum well channel region **608** transistor (on the left side of FIG. **23**) and a non-quantum well channel transistor (on the right side of FIG. **23**, also referred to as a “standard” transistor) on the same substrate **602**, according to one embodiment of the present invention. In some embodiments, germanium quantum well channel transistors, such as those shown and described in FIGS. **1-21**, may be used as PMOS transistors while other types of transistors, such well known silicon transistors that have been widely used for decades, may be used as NMOS transistors. These combinations of different types of transistors may make up CMOS circuitry in various different systems, such as a computer central processing unit.

In the embodiment shown in FIG. **23**, the germanium quantum well channel region **608** transistor may have any structure as described herein. One such structure is a substrate **602**, buffer region **604**, bottom barrier region **606**, channel region **608** consisting substantially of germanium, spacer region **610**, doped region **612**, upper barrier region **614**, gate dielectric **616**, gate electrode **618**, source region **620** and drain region **622**. There may be an isolation region **780** between the germanium quantum well channel region **608** transistor and the group III-V material quantum well channel region **708** transistor. Trenches may have been formed in the substrate **602** and then filled in by the regions of the germanium quantum well channel region **608** transistor to result in the device **800** shown in FIG. **23**. In other embodiments, such trenches may be avoided, in which case the germanium quantum well channel region **608** transistor may extend above the non-quantum well channel transistor.

The standard transistor may take one of many different structures and use many different materials, as is known in the art. In one embodiment, it includes a gate dielectric **804** and a gate electrode **806** on the gate dielectric **804**. Adjacent sidewalls **808** of the gate dielectric **804** and gate electrode **806** are spacers **810**. In the substrate **602** on either side of the gate dielectric **804** and gate electrode **806** are a source region **812** and a drain region **814**. Between the source region **812** and drain region **814** in the substrate **602** is a channel region **816**. The standard transistor may have a silicon dioxide gate dielectric **804** and polysilicon gate **806**, a high-k gate dielectric **804** and a metal gate **806**, may be a planar or multigate transistor, and take various other forms and use various materials.

As, in some embodiments, a germanium quantum well channel transistor may provide better PMOS performance, and a standard transistor may provide better NMOS performance, the use of both types of transistors on a single substrate **602** may provide better overall device **800** performance than if just one type of transistor were used for both NMOS and PMOS transistors.

The foregoing description of the embodiments of the invention has been presented for the purposes of illustration and description. It is not intended to be exhaustive or to limit the invention to the precise forms disclosed. This description and the claims following include terms, such as left, right,

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top, bottom, over, under, upper, lower, first, second, etc. that are used for descriptive purposes only and are not to be construed as limiting. For example, terms designating relative vertical position refer to a situation where a device side (or active surface) of a substrate or integrated circuit is the “top” surface of that substrate; the substrate may actually be in any orientation so that a “top” side of a substrate may be lower than the “bottom” side in a standard terrestrial frame of reference and still fall within the meaning of the term “top.” The term “on” as used herein (including in the claims) does not necessarily indicate that a first layer “on” a second layer is directly on and in immediate contact with the second layer unless such is specifically stated; there may be a third layer or other structure between the first layer and the second layer on the first layer. The embodiments of a device or article described herein can be manufactured, used, or shipped in a number of positions and orientations. Persons skilled in the relevant art can appreciate that many modifications and variations are possible in light of the above teaching. Persons skilled in the art will recognize various equivalent combinations and substitutions for various components shown in the Figures. It is therefore intended that the scope of the invention be limited not by this detailed description, but rather by the claims appended hereto.

We claim:

1. A method of fabricating a microelectronic device, comprising:

forming a lower barrier region comprising a large band gap material;

forming a quantum well channel region comprising germanium on the lower barrier region;

forming an upper barrier region comprising a large band gap material on the quantum well region;

forming a spacer region on the quantum well channel region;

forming an etch stop region on the spacer region, the etch stop region comprising silicon and being substantially free from germanium;

forming a gate dielectric on the etch stop region;

forming a gate electrode on the gate dielectric;

forming a doped region on the lower barrier region, the doped region comprising silicon germanium doped with boron; and

forming a lower spacer region comprising silicon germanium on the doped region and under the quantum well channel region.

2. The method of claim 1, wherein forming the spacer region on the quantum well channel region comprises forming a silicon germanium spacer region on the quantum well channel region.

3. The method of claim 1, wherein forming the gate dielectric on the etch stop region comprises forming the gate dielectric directly on the etch stop region.

4. The method of claim 1, wherein forming the etch stop region on the spacer region comprises forming a first portion comprising silicon and forming a second portion on the first portion.

5. The method of claim 4, wherein forming the second portion comprises forming a silicon dioxide second portion.

6. The method of claim 5, wherein forming the gate dielectric on the etch stop region comprises forming the gate dielectric directly on the second portion of the etch stop region.

7. The method of claim 1, wherein forming the etch stop region on the spacer region comprises forming the etch stop region on the etch stop region, wherein the etch stop region has a thickness of less than twenty angstroms.

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8. The method of claim 1, wherein forming the lower barrier region comprises forming a silicon germanium lower barrier region.

9. The method of claim 1, wherein forming the lower barrier region comprises forming the lower barrier region from a group III-V material. 5

10. The method of claim 9, wherein forming the lower barrier region comprises forming a GaAs lower barrier region.

11. The method of claim 1, wherein forming the upper barrier region comprises forming a silicon germanium upper barrier region. 10

12. The method of claim 1, wherein forming the upper barrier region comprises forming the lower barrier region from a group III-V material.

13. The method of claim 1, wherein forming the lower barrier region, forming the quantum well channel region, forming the upper barrier region, forming the spacer region, forming the etch stop region, forming the gate dielectric, and forming the gate electrode are all part of forming a p-type transistor, and further comprises forming an n-type transistor comprising: 15 20

forming a lower barrier region comprising a group III-V material;

forming a quantum well channel region comprising a group III-V material on the lower barrier region;

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forming an upper barrier region comprising a group III-V material on the quantum well region;

forming a gate dielectric on the quantum well channel region and not in contact with the quantum well channel region; and

forming a gate electrode on the gate dielectric.

14. The method of claim 1, wherein forming the lower barrier region, forming the quantum well channel region, forming the upper barrier region, forming the spacer region, forming the etch stop region, forming the gate dielectric, and forming the gate electrode are all part of forming a p-type transistor, and further comprises forming an n-type transistor comprising: 10

forming a source region in a substrate; 15

forming a drain region in the substrate;

forming a channel region in the substrate and between the source and drain regions;

forming a gate dielectric on the channel region, wherein the channel region has side walls;

forming a gate electrode on the gate dielectric and having side walls; and

forming spacers adjacent the side walls of the gate dielectric and adjacent the side walls of the gate electrode.

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